

# Work Order ID 65412

Monday, January 17, 2011 9:05:47 AM



Page 1

|                |                   |            |      |       |       |  |
|----------------|-------------------|------------|------|-------|-------|--|
| Item ID:       | D3651-041         | Accept     |      | Setup | Start |  |
| Revision ID:   |                   |            |      |       |       |  |
| Item Name:     | Aft Base Assembly |            |      |       | Stop  |  |
| Start Date:    | 1/18/2011         | Start Qty: | 1.00 |       |       |  |
| Required Date: | 1/31/2011         | Req'd Qty: | 1.00 |       |       |  |
| Reference:     |                   |            |      |       |       |  |
|                |                   |            |      |       |       |  |

|            |               |           |       |                 |            |  |       |  |     |       |  |
|------------|---------------|-----------|-------|-----------------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | <u>mf</u> | Date: | <u>11-01-17</u> | Tooling:   |  | Date: |  | Run | Start |  |
|            | QC:           |           | Date: |                 | SPC (Y/N): |  | Date: |  |     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3651    | Rev B        |

|           |          |      |  |  |  |  |  |  |  |
|-----------|----------|------|--|--|--|--|--|--|--|
| 100       | Pick Kit | 0.00 |  |  |  |  |  |  |  |
|           |          |      |  |  |  |  |  |  |  |
| Packaging | Memo     | 0.00 |  |  |  |  |  |  |  |
| Packaging |          |      |  |  |  |  |  |  |  |

SB 11/01/20 @

|           |  |      |  |  |  |  |  |  |  |
|-----------|--|------|--|--|--|--|--|--|--|
| 110       | Small Fab  | 0.00 |  |  |  |  |  |  |  |
|           |  |      |  |  |  |  |  |  |  |
| Small Fab | Memo   | 0.00 |  |  |  |  |  |  |  |
| Small Fab | 1-Assemble as per dwg D3651 □ 2- Seal all mating surfaces and gaps using<br>Proseal 700 fire wall sealant as per dwg D3651 □ Batch: <u>M116573</u> □ 3-install<br>D3651-1 using 3M high per formance contact adhesive 1357 as per dwg<br>D3651 □ Batch: <u>M105625</u> |      |  |  |  |  |  |  |  |

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|                 |   |      |  |  |  |  |  |  |  |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120             | QC5- Inspect part completeness to step on W/O | 0.00 |  |  |  |  |  |  |  |
|                 |   |      |  |  |  |  |  |  |  |
| QC              | Memo  | 0.00 |  |  |  |  |  |  |  |
| Quality Control |   |      |  |  |  |  |  |  |  |

SB 11/01/20

④

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 65412**

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Item ID: D3651-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Base Assembly

Start Date: 1/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

w/0 0.00  
D3646-041 SB 11/01/20  
365405

①

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/2010

ME

11-01-20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, January 17, 2011 9:05:44 AM

Page 1

Work Order ID: 65412

Parent Item: D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 1/18/2011


Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC  
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC  
IPP Rev:C ecn1162 08-04-02 DD verified by: EC


| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|  |  |           |    |  |  |     |      |          |    |    |  |  |  |
|--|--|-----------|----|--|--|-----|------|----------|----|----|--|--|--|
| CR3523-4-02  |  | Purchased | No |  |  | 100 | Each | 644.0000 | 58 | 58 |  |  |  |
|  |  |           |    |  |  |     |      |          |    |    |  |  |  |
| RIVET  |  |           |    |  |  |     |      |          |    |    |  |  |  |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST312    | 300     |          |
| 115768   | 300     |          |
| ST313    | 344     |          |
| 116022   | 44      |          |
| 116391   | 200     |          |
| 116471   | 100     |          |

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58

|  |  |              |    |  |  |     |      |        |   |   |  |  |  |
|--|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D3651-043  |  | Manufactured | No |  |  | 110 | Each | 5.0000 | 1 | 1 |  |  |  |
|  |  |              |    |  |  |     |      |        |   |   |  |  |  |
| Flange Weldment  |  |              |    |  |  |     |      |        |   |   |  |  |  |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST189    | 5       |          |
| 45830    | 1       |          |
| 61746    | 4       |          |

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1

|  |  |              |    |  |  |     |      |         |   |   |  |  |  |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D3651-1  |  | Manufactured | No |  |  | 110 | Each | 12.0000 | 1 | 1 |  |  |  |
|  |  |              |    |  |  |     |      |         |   |   |  |  |  |
| Gasket   |  |              |    |  |  |     |      |         |   |   |  |  |  |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST188    | 12      |          |
| 45831    | 4       |          |
| 61748    | 8       |          |

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1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, January 17, 2011 9:05:44 AM

Page 2

Work Order ID: 65412

Parent Item: D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 1/18/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3651-11

Manufactured No

110

Each

3.0000

1

1



Gasket



SS 1/10/20

Location

Loc Qty

Loc Code

GA

3

B65162

1

44675

1

45452

2

D3651-13

Manufactured No

110

Each

5.0000

1

1



Outside Doubler



SS 1/10/20

Location

Loc Qty

Loc Code

GA

1

44676

1

ST188

4

62493

4

D3651-9

Manufactured No

110

Each

6.0000

1

1



Inside Doubler



SS 1/10/20

Location

Loc Qty

Loc Code

ST188

6

45451

2

62814

4

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Shop Packet Print

Page 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

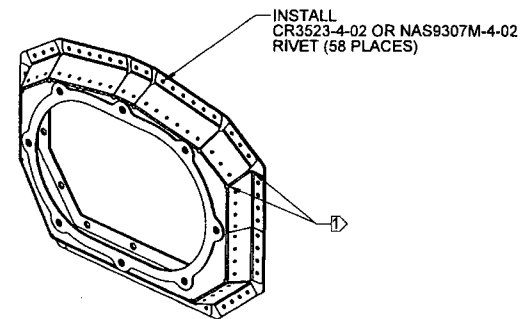
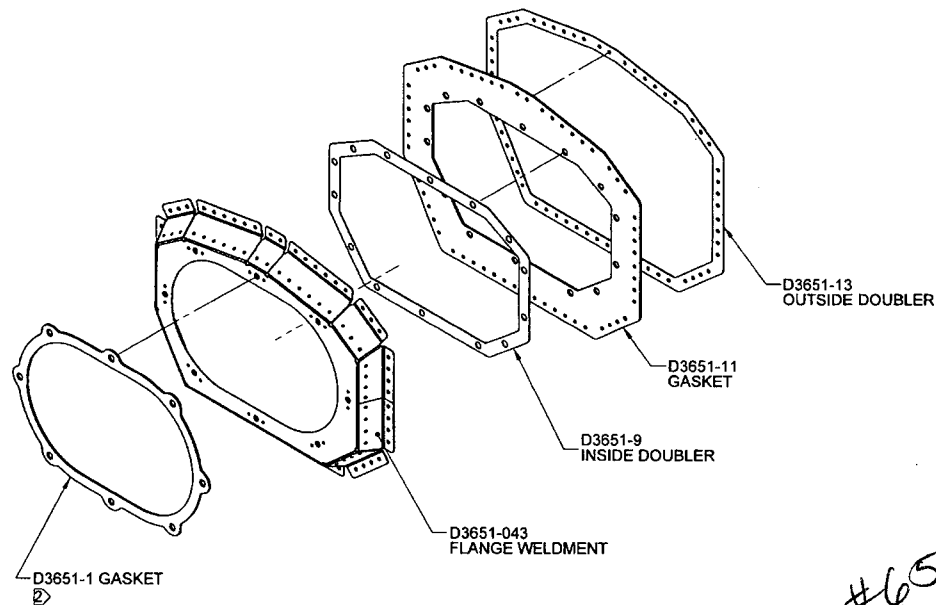
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



#### PART LIST

| QTY<br>-041 | PART NUMBER                     | DESCRIPTION       |
|-------------|---------------------------------|-------------------|
| X           | D3651-041                       | AFT BASE ASSEMBLY |
| 1           | D3651-043                       | FLANGE WELDMENT   |
| 1           | D3651-1                         | GASKET            |
| 1           | D3651-9                         | INSIDE DOUBLER    |
| 1           | D3651-11                        | GASKET            |
| 1           | D3651-13                        | OUTSIDE DOUBLER   |
| 58          | CR3523-4-02 or<br>NAS9307M-4-02 | RIVET             |

#### D3651-041 AFT BASE ASSEMBLY

##### D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

|            |  |  |          |
|------------|--|--|----------|
| B          | SHEET 1: GENERAL UPDATE<br>SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE<br>SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE<br>SHEET 7: 5.514 WAS 5.504 | RF   | 08.01.07 |
| A          | NEW ISSUE  | RF   | 07.11.07 |
| REV.       | DESCRIPTION  | BY   | DATE     |
| DESIGN     | RF   | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA  |          |
| DRAWN      | RF   | DRAWING NO. REV. B<br>D3651 SHEET 1 OF 9   |          |
| CHECKED    | RF   | TITLE SCALE<br>AFT BASE ASSEMBLY 1:4   |          |
| MFG. APPR. | RF   | COPYRIGHT © 2007 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |          |
| APPROVED   | RF   |  |          |
| DE APPR.   | RF   |  |          |
| DATE       | 08.01.07   |  |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

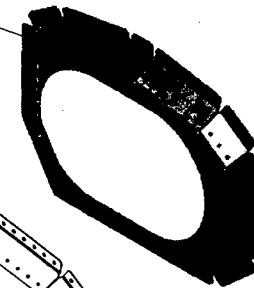
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

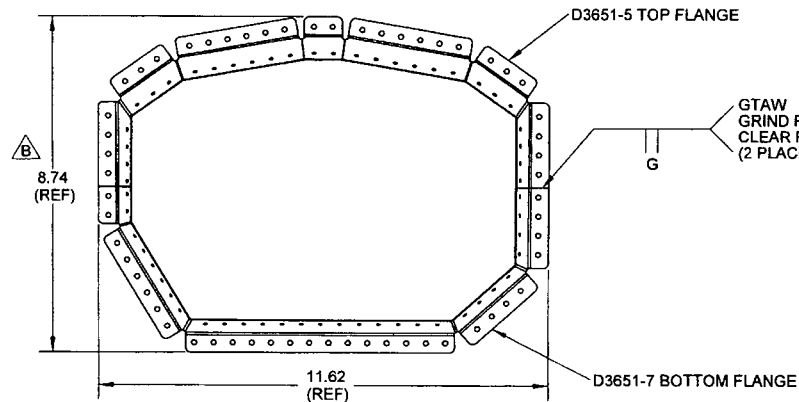
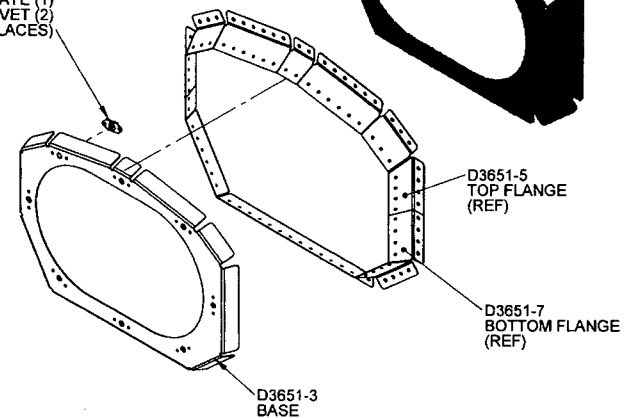
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

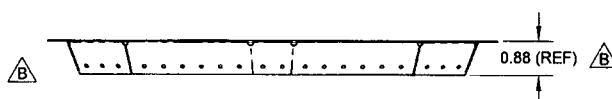
TRANSFER DRILL Ø0.129 (#30 DRILL)  
FROM D3651-5/-7 TO D3651-3  
INSTALL CR3523-4-02 OR NAS9307M-4-02  
RIVETS (57)



MS21060-3K NUTPLATE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



G  
GTAW  
GRIND FLAT TO  
CLEAR FASTENERS  
(2 PLACES)



#65412

**D3651-043 FLANGE WELDMENT**

| QTY  | PART NUMBER                     | DESCRIPTION     |
|------|---------------------------------|-----------------|
| -043 |                                 |                 |
| X    | D3651-043                       | FLANGE WELDMENT |
| 1    | D3651-3                         | BASE            |
| 1    | D3651-5                         | TOP FLANGE      |
| 1    | D3651-7                         | BOTTOM FLANGE   |
| 16   | MS20427M3-3                     | RIVET           |
| 8    | MS21060-3K                      | NUTPLATE        |
| 57   | CR3523-4-02 or<br>NAS9307M-4-02 | RIVET           |

RELEASED  
08-03-27-14

- D3651-043 NOTES:**  
1) WELD PER QSI 004  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 0.76 lbs

|            |          |  |
|------------|----------|--|
| DESIGN     | RF       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA  |
| DRAWN      | RF       |  |
| CHECKED    | LE       | DRAWING NO. D3651  |
| MFG. APPR. | MA       | REV. B   |
| APPROVED   | MA       | TITLE AFT BASE ASSEMBLY  |
| DE APPR.   | MA       | SCALE 1:3  |
| DATE       | 08.01.07 | COPYRIGHT © 2007 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |

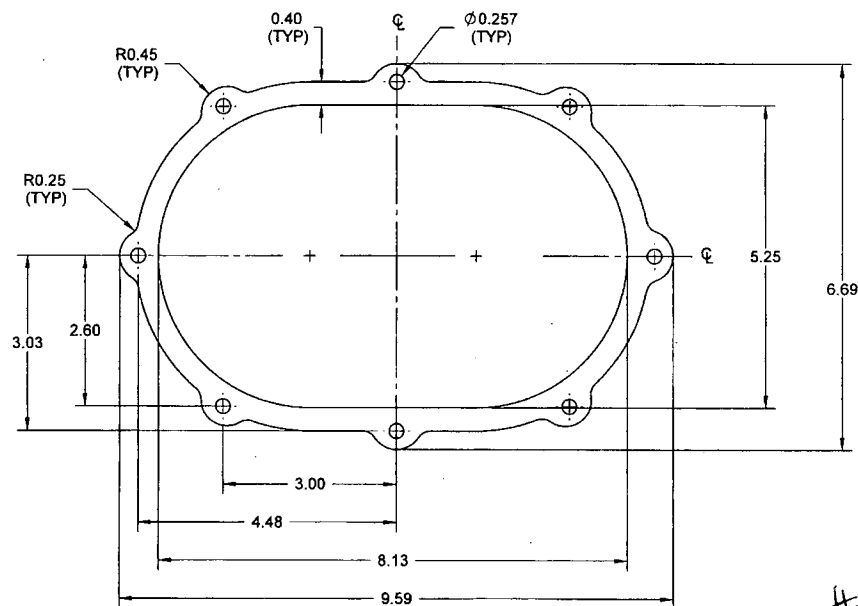
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



#65412

# **D3651-1 GASKET**

## **NOTES:**

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT  $\phi$
- 8) WEIGHT: 0.09 lbs

|            |                    |  |        |
|------------|--------------------|--|--------|
| DESIGN     | RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |        |
| DRAWN      | RF                 |  |        |
| CHECKED    | <i>[Signature]</i> | DRAWING NO. <b>D3651</b>                                 | REV. B |
| MFG. APPR. | <i>[Signature]</i> | SHEET 3 OF 9   |        |
| APPROVED   | <i>[Signature]</i> | TITLE  | SCALE  |
| DE APPR.   | <i>[Signature]</i> | <b>AFT BASE ASSEMBLY</b>                                 |        |
| DATE       | 08.01.07           | 1:2  |        |

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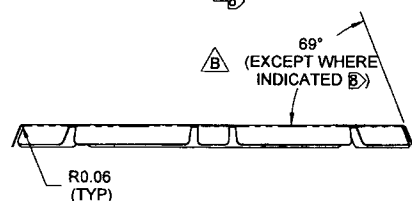
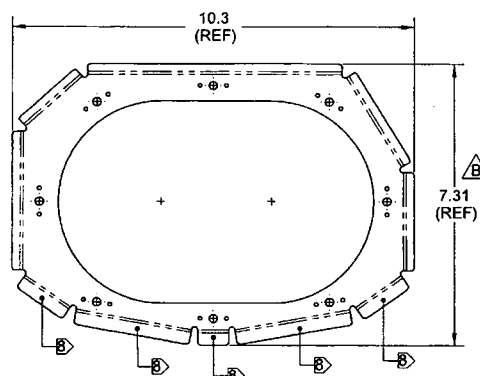
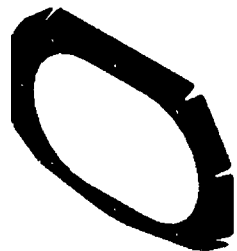
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

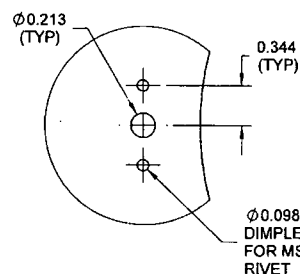
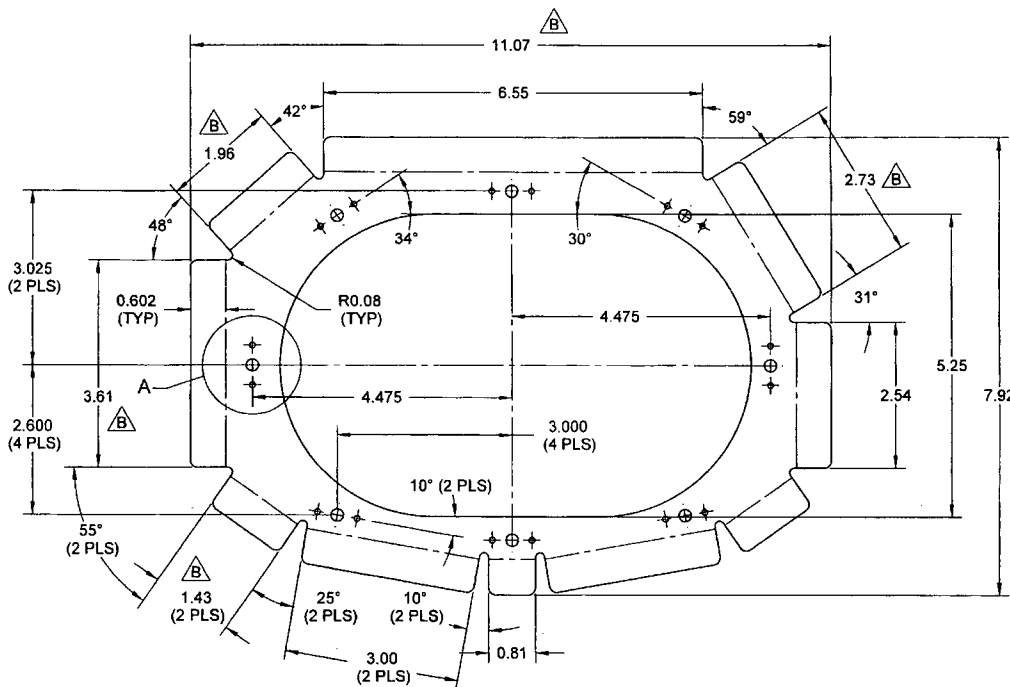
**NOTE:** Date & initial all entries



**D3651-3 BASE**  
(MAKE FROM D3651-3F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



**DETAIL A**

**D3651-3F FLAT PATTERN**

#65412

08-03-27-14

|  |          |  |              |
|--|----------|--|--------------|
| DESIGN   | RF       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN  | RF       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  | LE       | DRAWING NO.                            | REV. B       |
| MFG. APPR.   | ME       | D3651                                  | SHEET 4 OF 9 |
| APPROVED   | ME       | TITLE                                  | SCALE        |
| DE APPR.   | ME       | AFT BASE ASSEMBLY                      | 1:2          |
| DATE   | 08.01.07 | COPYRIGHT © 2007 BY DART AEROSPACE LTD |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

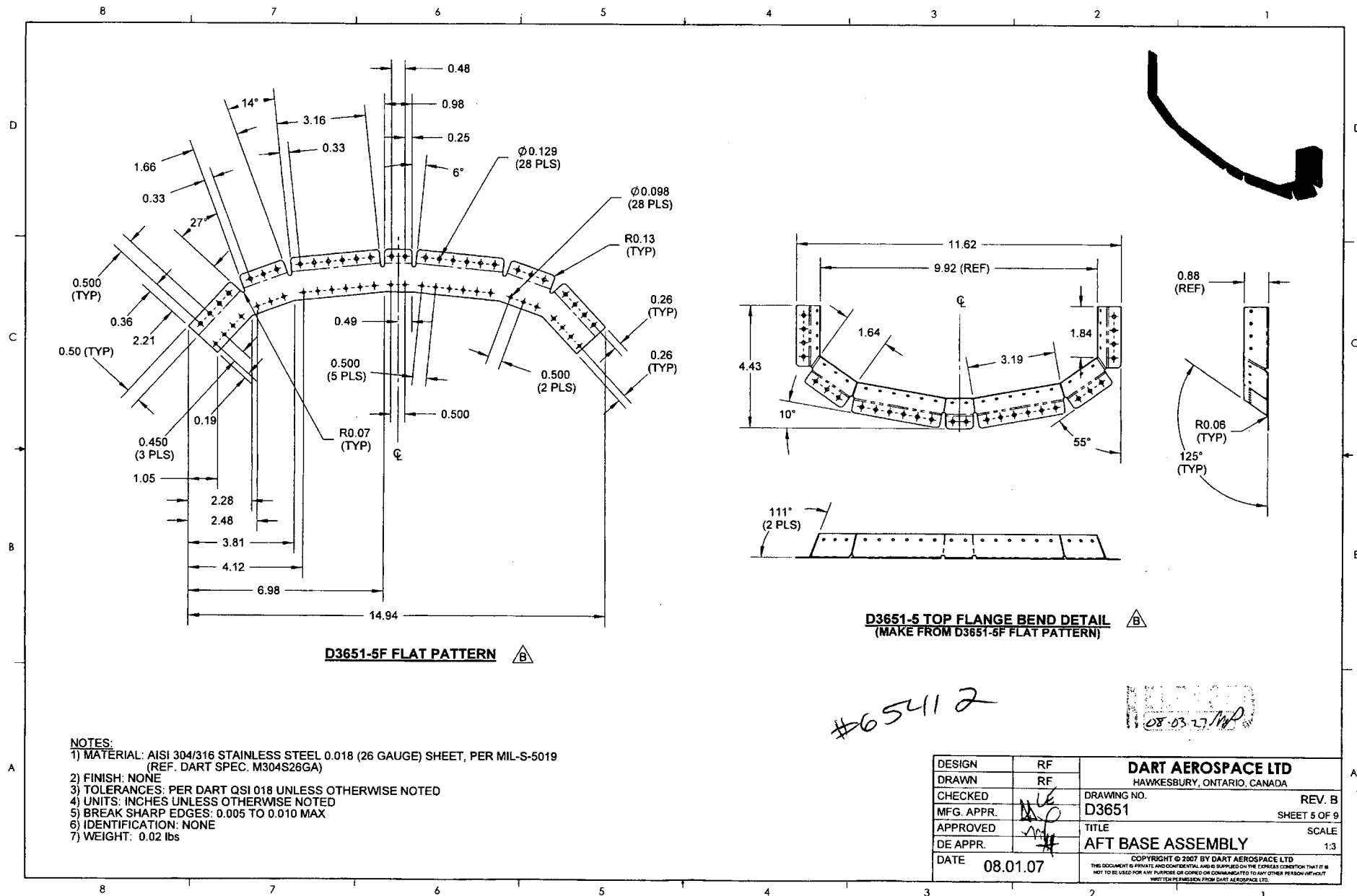
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

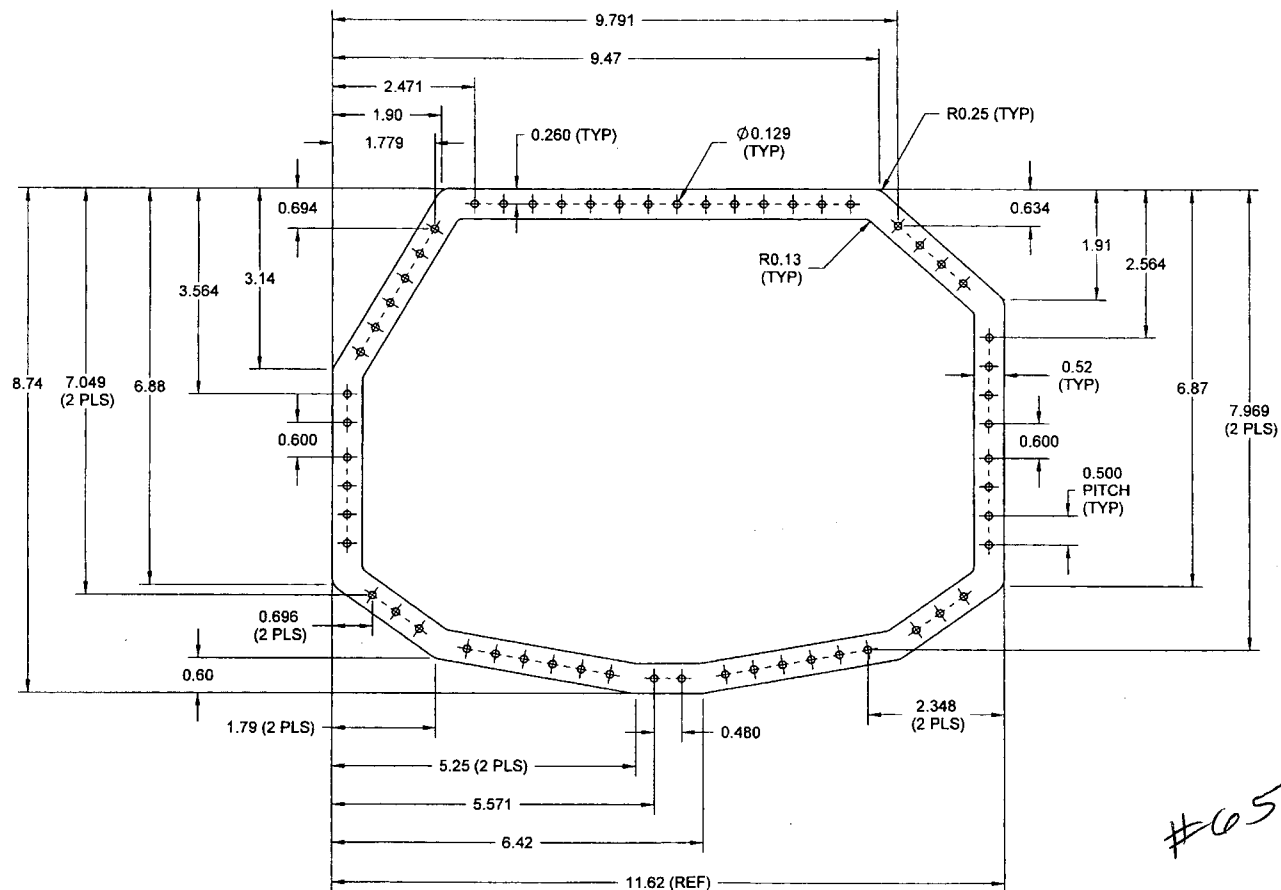
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries








# **D3651-13 OUTSIDE DOUBLER**

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

|  |   |  |              |
|--|---|--|--------------|
| DESIGN   | RF  | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN  | RF  | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  |  | DRAWING NO.<br><b>D3651</b>            | REV. B       |
| MFG. APPR.   |  |  | SHEET 9 OF 9 |
| APPROVED   |  | TITLE                                  | SCALE        |
| DE APPR.   |  | <b>AFT BASE ASSEMBLY</b>               | 1:2          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries